

Date: Wednesday, 07/03/2007 2:27:09 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: MOUNTING LUG		
Job Number	: 30889		Part Number	: D30403		
Estimate Number	: 11535		Drawing Number	: D3040 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 07/03/2007	S.O. No. : <u>N/A</u>	Drawing Revision	: B		
Prsh Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 30/03/2007 Qty: 20 Um: Each		
Previous Run	: 30889					
Written By	:					
Checked & Approved By	:					
Comment	: Est:B 01.11.08 Revised Step 2 and Added Inspection Level 21 S M Est Rev:A Now on Waterjet 07-03-07 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"
Comment: Qty.: 0.3718 f(s)/Unit Total : 7.4361 f(s) 6061-T6 Bar .178" x 4.0" Material: 6061-T6 alum plate 0.188" thick		
Batch: <u>m103857</u> <u>m1 07 04 10</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3041 Dwg Rev: <u>B</u> <u>m1 07 04 10</u> Prog Rev: <u>B</u>		
2-Deburr if necessary <u>07 04 17</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<u>m1 07 04 10</u>		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>07/04/12</u>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>W25</u> <u>07.04.18</u>		

Date:
User:

Wednesday, 07/03/2007 2:27:09 PM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30889

Part Number: D30403

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC21	FINAL INSPECTION/W/O RELEASE
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(21)

Comment: FINAL INSPECTION/W/O RELEASE

17072019

Job Completion



A 07.07.19

Date: Friday, 2/23/2007 8:31:53 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	MOUNTING LUG		
Job Number	30899			Part Number	D30403		
Estimate Number	11535			Drawing Number	D3040 REV B		
P.O. Number				Project Number	N/A		
This Issue	2/23/2007	S.O. No.		Drawing Revision	B		
Prsh Rev.	NC			Material	:		
First Issue	/ /	Type	MACHINED PARTS	Due Date	3/30/2007	Qty:	20
Previous Run				Um:	Each		
Written By							
Checked & Approved By	<u>07.02.23</u>						
Comment	Est.B 01.11.08 Revised Step 2 and Added Inspection Level 21S			M			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0187X04000	6061-T6 Bar .178" x 4.0"	
		Comment: Qty.: 0.3718 f(s)/Unit Total : 7.4361 f(s) 6061-T6 Bar .178" x 4.0"	
		Material: 6061-T6 alum plate 0.188" thick	Batch:
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 4.25" x 3.48" tol.+/-0.010"	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio FA155 Tumble and deburr rough edges after tumbling	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
6.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: P1 Date: 01/04/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:31:54 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 30889

Part Number: D30403

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2/23/07 104119

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

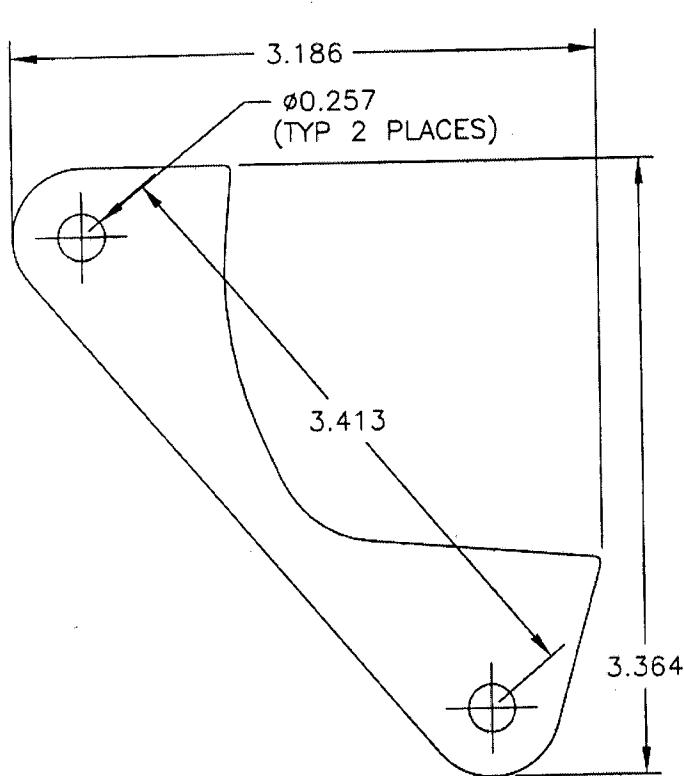
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

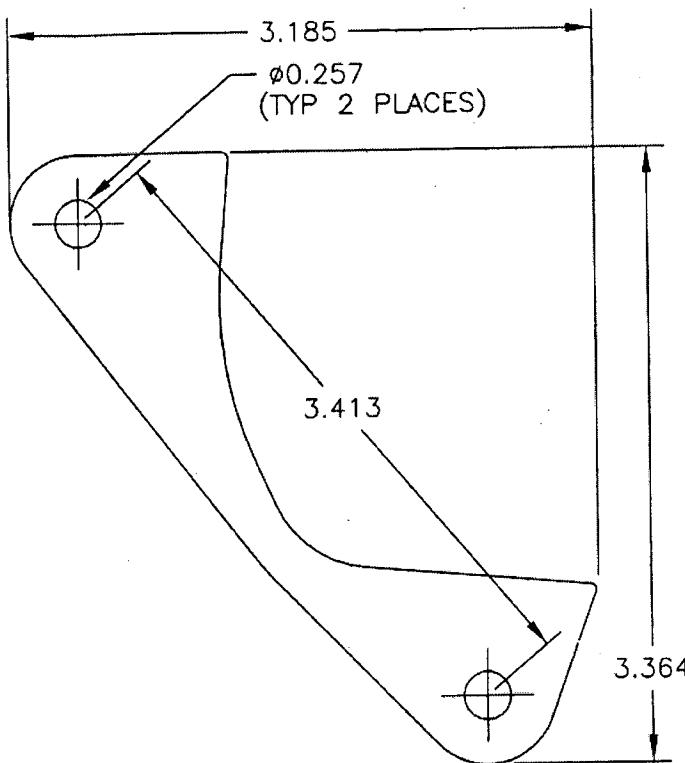


DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3040
DATE		REV. B SHEET 1 OF 1
01.09.04		TITLE MOUNTING LUG
A	01.06.27	SCALE 1:1
B	01.09.04	NEW ISSUE
		CHANGED PROFILE 5 DEGREES

RELEASED
01.09.07



D3040-1



D3040-3

NOTES

- 1) MACHINE PARTS PER DRAWING FILE "D3040-B1.DWG"
- 2) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.188 THICK
(REF M6061T6S.188)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020 MAX
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
30889

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OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

DART AEROSPACE LTD	Work Order:	30889
Description: Mounting Lug	Part Number:	D 3040-3
Inspection Dwg: D3040 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.257$	$+0.006 -0.001$	0.258	✓		VERN	
B 3.413	$+/- 0.010$	3.413	✓		VERN	
C 0.188	$+/- 0.010$	0.187	✓		VERN	
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by:	<i>M. M.</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07/04/10	Date:	07/04/12	Date:	N/A

Rev	Date	Change New Issue	Revised by	Approved
			KJ/RF	

